

Date: Tuesday, 6/12/2007 3:00:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEM
Job Number	: 32898		
Estimate Number	: 11107		
P.O. Number	: <i>N/A</i>	Part Number	: D34071
This Issue	: 6/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3407 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 30401	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 6/19/2007
Checked & Approved By	: <i>[Signature]</i> 07.06.12	Qty:	12 Um: Each
Comment	: Est Rev: A 05.10.18 New issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174R0750	Inventory
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Comment: Qty.: 0.3843 f(s)/Unit Total : 4.6116 f(s)
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)
 Batch: *M 103885 DSP 07/07/18*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA596 Rev: *AA* & Dwg D3407 Rev: *C*

2-Deburr

DSP 07/07/18 (13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/07/18 (13)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

SP 07.07.22 (13)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SP 07.07.22 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/10/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 32898

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 07/10/31

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A

07-10-31

13

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(13)

07/10/31

Job Completion



W 07-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32898
Description: Tow Ring		Part Number:	D3407-1
Inspection Dwg: D3407	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

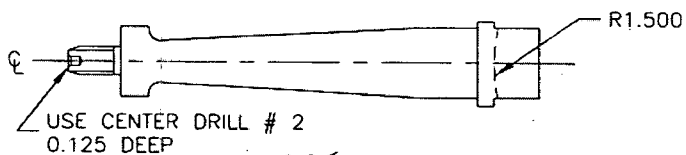
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	+/-0.010	5.272	✓	-		
4.250	+0.000/-0.010	4.250	✓			
3.250	+/-0.010	3.250	✓			
0.500	+/-0.010	0.499	✓			
0.500	+/-0.010	0.500	✓			
0.470	+/-0.010	0.470	✓			
Ø0.625 ± 0.010	$\pm 0.008/-0.001$	0.6255	✓			
Ø0.750 ± 0.010	$\pm 0.008/-0.001$	0.747	✓			
Ø0.625 ± 0.010	$\pm 0.008/-0.001$	0.622	✓			
Ø0.363 ± 0.010	$\pm 0.006/-0.001$	0.367	✓			
0.063 Ref	+/-0.010	0.063	✓			
R0.020	+/-0.010	0.02	✓			
0.550	+/-0.010	0.547	✓			
0.625	+/-0.010	0.629	✓			
0.250	+0.010/-0.000	0.251	✓			
0.150	+/-0.010	0.145	✓			
MOW = 0.266	+/-0.001	0.266	✓			

Measured by:	DJP
Date:	07/07/18

Audited by:	[Signature]
Date:	07.07.18

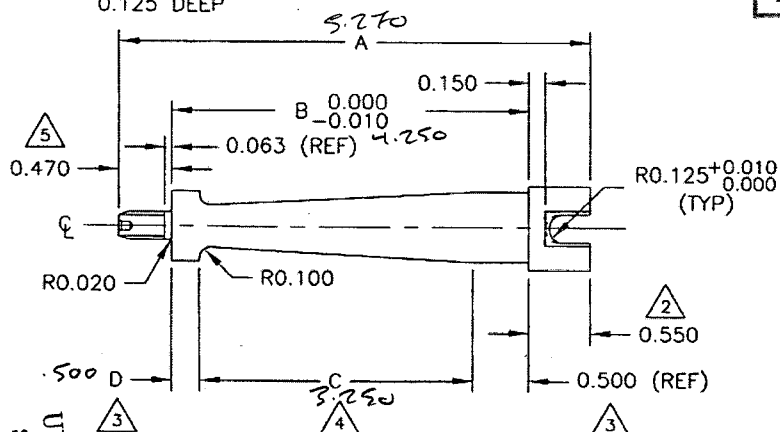
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	[Signature]



RELEASED

05 09.12



D3407-5 RING

1/8

USE D3407-1 STEM
FOR -041
USE D3407-3 STEM
FOR -043

PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

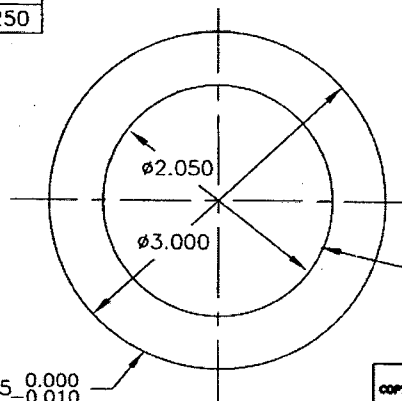
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3407-5 RING

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

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C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE USA, INC. PORT WILMOUTH, NJ
CHECKED	APPROVED	DRAWING NO. D3407
DATE	05.09.09	TOW RING

NO. 22848

WORK ORDER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE

1:1